

Date: Thursday, 2/21/2008 9:26:02 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOCK PLATE
Job Number : 37563	
Estimate Number : 10332	
P.O. Number :	Part Number : D2534
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D2534 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 36662	Material :
Written By :	Due Date : 2/27/2008 Qty: 40 Um: Each
Checked & Approved By : <u>080221</u>	
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now on Waterjet 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0448 sf(s)/Unit Total : 1.7934 sf(s)

304/316 .125 Sheet

(M304S11GA)

Batch: 104934

IB 8-2-25

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2734

Dwg Rev: DProg Rev: D

2-Deburr if necessary

08/02/26

(52) + 1 scrap

(53)

(53)

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-2-25

(52)



(PTO)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK

0802-27

(52)



Comment: SECOND CHECK

counted

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/02/27 (52)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2534 PAR #: NA Fault Category: Prod / fms. pass ^{med & small} NCR: Yes No DQA: D Date: 08/02/27
 QA: N/C Closed: H Date: 08/02/27

NCR: 37563		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0802-27	20	1 part scrap. Part bent when breaking the tab off. AS1012	AS1012	Scrap & destroy No replace.	SAD AS 08/02/27	AS 0802-27	AS1012	0702-27

NOTE: Date & initial all entries

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Drawing Name: LOCK PLATE

Job Number: 37563

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



52

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/27

Job Completion



2008/2/27

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

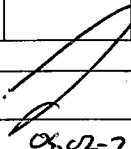
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	37563
Description: Lock Plate		Part Number:	D2534
Inspection Dwg: D2534 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

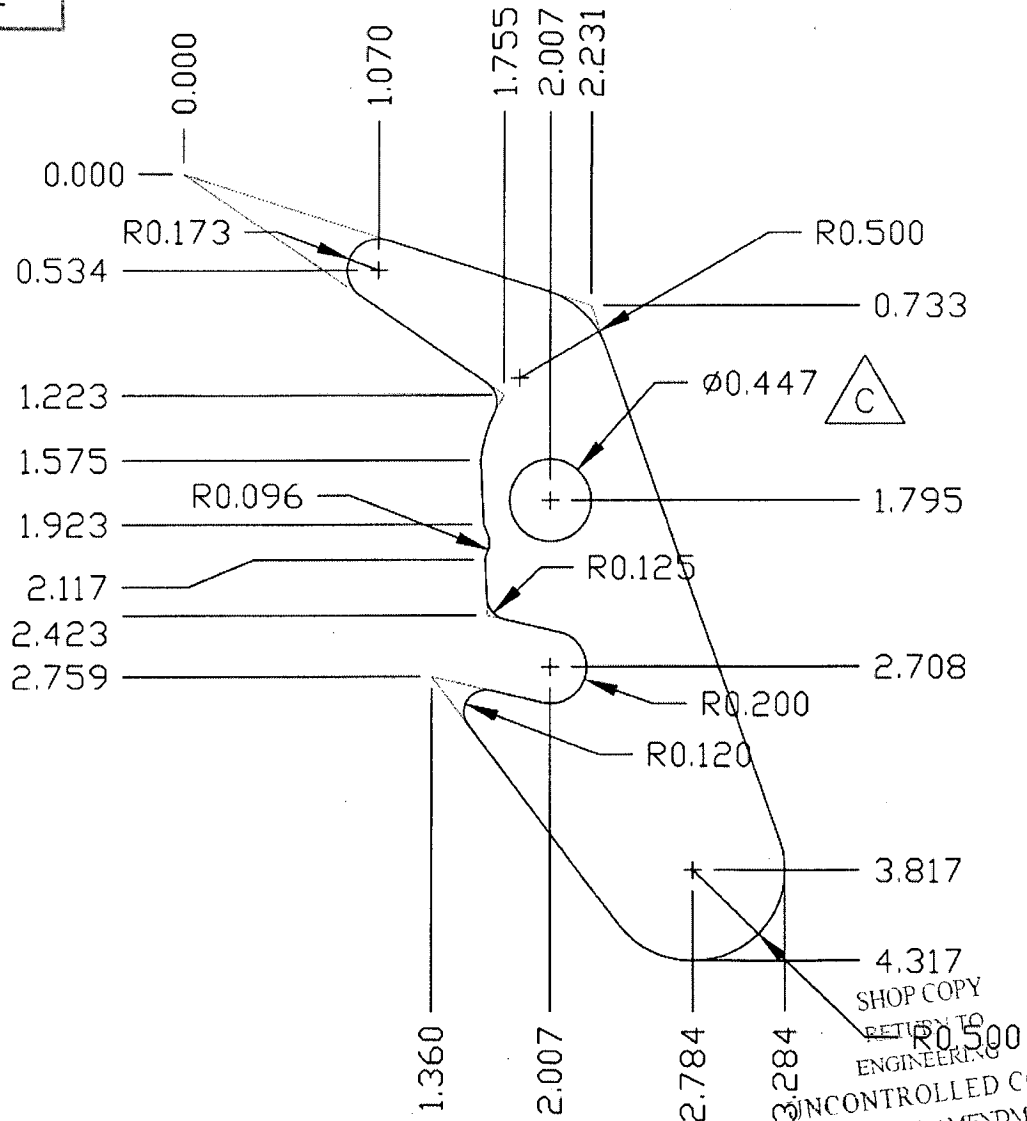

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.447	+0.006/-0.001	.448	X			
R0.500	+/-0.010	.500	X			
R0.173	+/-0.010	.173	X			
R0.096	+/-0.010	.096	X			
R0.125	+/-0.010	.125	X			
R0.120	+/-0.010	.120	X			
R0.200	+/-0.010	.200	X			
0.125	+/-0.010	.120	X			

Measured by: LB	Audited by: 	Prototype Approval:	N/A
Date: 8-2-25	Date: 08-02-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM 	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2534	REV. D SHEET 1 OF 1
DATE 04.12.14	TITLE LOCK PLATE		SCALE 1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 **D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37563

